

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006412**Date Inspected:** 28-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 4/28/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections and their associated built up plate sections in either the Fabrication shop #4 or Foundry Shop at Japan Steel Works.

West Deviation Saddles:

W2E3 - Section undergoing welding in Fabrication shop #4. H.Mitsumore 81-5438, R.Iizuka 06-2643, T. Ohkawa 03-3091 and K.Kobayashi 08-5023 are Flux Core arc welding (FCAW) joints E3Y-4U-1, E3Y-4U-2, E3Y-13U and E3-14U respectively, Rib plate to Rib cast, in accord with procedure SJ-3011-7 (for non-standard joints), parameters were verified by QC CWI Mr Chung Fu Kuan and found to be in compliance with contract documents and special provisions.

W2W1 - Cast in Fabrication Shop #4, has anti-distortion bracing tacked in place in upper part of trough.

W2W2 - Built up plate portion is being welded, joint W2Y-17L-1, -2 by two welders, R.Iizuka 06-2643 and T. Watanabe 08-5153 respectively. Joints W2Y-13L and W2Y-14L were in process by J.Yaegashi 07-2941 and M. Kato 08-5018 per same procedure SJ3011-2, FCAW process, per applicable contract documents and special provisions.

W2W3 - NDE Technician is mapping out grid on Casted portion in preparation for final testing.

Tower Saddles:

T1-2 - Saddle section, has been Post Weld Heat Treated (PWHT) and is cleaning, Magnetic Particle and Ultrasonic inspection.

T1-3 - Located in #4 Fabrication Shop. NDT Technician R.Kumagai #132 was in process performing a "For

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information only" examination of all buttered locations. Remaining location intended for temporary anti-distortion bars at inside trough completed by welder R.Kato 07-4510, per SJ3012-1-2. All pertinent parameters were being met and were in accord with contract documents and special provisions.

East Saddles:

E2W1 - Volumetric Ultrasonic testing being done to cast section in Foundry by H. Kohama (#86), angle beam testing utilizing a 45 degree transducer. It appears at this time that all contract documents, special provisions are being met at this time, area under scrutiny during QAI's review was side opposite ID side .

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
